

SHY OCT 25

Work Order ID 74935

74935

Page 1

October 13, 2011 1:05:25 PM

Item ID: D135-751-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Installation

Start Date: 10/13/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/21/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/13 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

0.00

100

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

m/ 11 11 30 (1)
JJ for M.L.J 11-11-29
(1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Required Date: 10/21/11 Req'd Qty: 1.00

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Customer:

Reference:

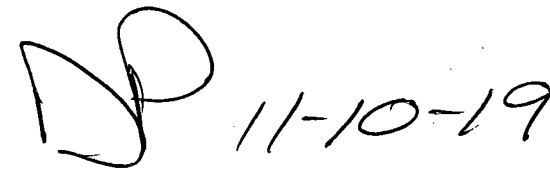
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Skidtubes	0.00							
120									
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. *****DO NOT OPEN AFT CAP HOLES*****								
	7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892. Open holes to 0.297"								
	9-Open Aft & Fwd Cap holes using .208" drill.								
	10-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	11-Open ground wire hole .297" section E-E								
	12- Section G-G holes must be laid out manually, open to #30.								
	13-Deburr holes.								



11-10-19

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Stop *NS2*

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Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

140 QC5- Inspect part completeness to step on W/O

0.00

0.00

140

QC

Memo

Quality Control

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	0.00							
170									
Skidtubes	Memo	0.00							
Skidtubes	1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F"								
	2-Counter Sink X-BOLT holes as per Dwg D3507								
	3-Deburr and blow out chips from inside of tube.								
	4-Bond web as per Dwg D3507 & QSI 015								
	A/R 241 Sike Flex Batch: <u>M118293</u>								
	Exp Date: <u>12-05-05</u>								
	start time: <u>2h30</u>								
	end time: <u>2h30</u>								
	5-Weld x-bolt (D3504-1/3) spacers as per Dwg D3507 and Detail C-C & D-D								
	A/R AL ROD Batch: <u>M117884</u>								
	6-Grind welds flush								
	7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B								
	8-Deburr Rivet holes.								

DP 11-10-19

SAD 11-10-19

SAD 11-10-20

SAD 11-10-20

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Customer:

Reference:

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC10- Inspect visual per QSI004- ground welds	0.00							
180		0.00							
QC	Memo								
Quality Control									
190	Skidtubes	0.00							
190		0.00							
Skidtubes	Memo								
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200		0.00							
QC	Memo								
Quality Control									

8/10/20

① 8/10/21
DD 11-11-23

8/11/23

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210 Pressure Wash per QSI005 4.3

0.00

210

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BR. 11-11-24.

220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Memo

0.00

Powder Coating

START TIME: *2:45*

OVEN TEMPERATURE: *320°F*

FINISH TIME: *3:15*

M 118434

NG m-f 11/11/24

230 QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

1 φ M 11/11/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Required Date: 10/21/11 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260	HandFinishing	0.00							
260	HandFinish	0.00							

Hand Finishing

✓ Install Wearplate & Ground Wire inserts as per Dwg D3507.

✓ 1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: 11119443
 Exp Date: 12/01

✓ 3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: 11119443
 Exp Date: 12/01

✓ 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 1110348

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 1118988

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Quality Control

Dart Aerospace Ltd

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 Required Date: 10/21/11 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: _____								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

U 11.11.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 13, 2011 1:05:29 PM

Page 1

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A06-06-21 New Issue JLM
 IPP Rev: B 06-12-18 As per Rev B JLM
 IPP Rev: C 07-12-11 ECN 1036 as per rev B DD
 IPP Rev: D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev: E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev: F
 10.06.09 remove seq 110 DD verf: EC IPP Rev: G 10.09.17
 added D3507-1-bent EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130

Purchased

No

Each

1,099.000

38

AI S7-1032-130

Insert

**

1119530 (x38) Jul 11/11/28

Location

Loc Qty

Loc Code

ST281

922

118966

922

ST282

177

117717

31

118386

146

D3507-1-BENT

Manufactured

No

120

Each

3.0000

1

1

D3507-1-BFNT

Skidtube Assembly EC135

**

Location

Loc Qty

Loc Code

LG

3

71201

1

72564

2

11-10-19

Dart Aerospace Ltd

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October 13, 2011 1:05:29 PM

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Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 13.0000 2 2

D3504-1

Crossbolt Spacer

**

BE 11/10/20

Location

Loc Qty

Loc Code

LG

11

71130

11

2

LG001

2

53742

2

D3504-3 Manufactured No

170 Each 17.0000 1 1

D3504-3

Crossbolt Spacer

**

BE 11/10/20

Location

Loc Qty

Loc Code

LG001

17

53743

17

1

D3504-5 Manufactured No

170 Each 11.0000 2 2

D3504-5

Crossbolt Spacer

**

BE 11/10/20

Location

Loc Qty

Loc Code

LG

11

71226

11

2

D3505-1 Manufactured No

170 Each 0.0000 1 1

D3505-1

Web

B 75211

**

SAD 11-10-19

D3506-1 Manufactured No

190 Each 11.0000 4 4

D3506-1

Doubler

**

3

BE 11/10/20
DP 11-11-23

Location

Loc Qty

Loc Code

ST063

11

51789

11

1

74733

October 13, 2011 1:05:29 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

D3506-3 Manufactured No

190 Each

69.0000

2

D3506-3

Doubler

**

2 2 3

Location

Loc Qty

Loc Code

ST063

69

51790

69

MS20601-AD4W3

Purchased

No

190

Each

2,438.000

12

MS20601-AD4W3

Rivet

**

12 2 DP 11-11-23
10 BB

Location

Loc Qty

Loc Code

ST321

2438

114538

2438

ALS4-1032-225

Purchased

No

260

Each

2,660.000

1

AI S4-1032-225

Insert

**

1 11/11/28

Location

Loc Qty

Loc Code

ST282

2660

108696

808

110768

62

118386

860

118966

930

xl

Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 260 Each 1,987.000 31 31

AN3C4A

BOLT

**

1119328 (x 31) 11/11/28

Location	Loc Qty	Loc Code
ST350	1987	
117313	2	
117688	5	
117872	22	
118112	16	
118451	442	
118706	500	
118838	1000	

AN3C5A Purchased No 260 Each 1,350.000 2 2

AN3C5A

Bolt

**

1119328 (x 2) 11/11/28

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1343	
116419	28	
117343	144	
117764	169	
117872	2	
118451	500	
119127	500	

x 2

Dart Aerospace Ltd

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Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

265.0000

2

2

AN526C1032R10

Screw

**

Handwritten: 11/11/28

Location

Loc Qty

Loc Code

FP-B

91

108062

91

ST327

100

114494

100

ST328

74

110049

74

AN960C10L

NAS1149C0332

Purchased

No

260

Each

0.0000

33

33

***AN960C10L ***

washer

D2965

Manufactured

No

260

Each

41.0000

1

1

D2965

Cap, 105 Skidtube

**

Handwritten: 1149736 (x33) 11/11/28

**

Handwritten: 11/11/28

Location

Loc Qty

Loc Code

FP006

41

71371

41

D2965-3

Manufactured

No

260

Each

4.0000

1

1

D2965-3

Cap

**

Handwritten: 075254 (x1) 11/11/28

Location

Loc Qty

Loc Code

FP005

4

50560

1

71300

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

October 13, 2011 1:05:29 PM

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

D3492-1	Manufactured	No	260	Each	166.0000	4	4
D3492-1						**	HL 11/1/28
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	166	
69531	8	
73402	78	
<u>74444</u>	80	X4

D3492-3	Manufactured	No	260	Each	125.0000	4	4
D3492-3						**	HL 11/1/28
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	125	
71838	45	
<u>74447</u>	80	X4

D3492-7	Manufactured	No	260	Each	14.0000	2	2
D3492-7						**	HL 11/1/28
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FA-A	14	
<u>71881</u>	14	X2

D3508-1	Manufactured	No	260	Each	15.0000	1	1
D3508-1						**	HL 11/1/28
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP016	15	
61020	3	X1
72933	12	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

October 13, 2011 1:05:29 PM

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

D3508-3	Manufactured	No	260	Each	6.0000	1	1	
D3508-3								
Wearplate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	1	
38527	1	
FP21	5	
72169	5	

D3508-5	Manufactured	No	260	Each	21.0000	1	1	
D3508-5								
Wearplate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	21	
71688	9	
72416	12	

D3508-7	Manufactured	No	260	Each	8.0000	1	1	
D3508-7								
Wearplate								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP020	7	
72932	7	
FP021	1	
67739	1	

D3558-1	Manufactured	No	260	Each	15.0000	1	1	
D3558-1								
Gasket								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP014	15	
50925	3	
73561	12	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:05:29 PM

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

D3558-3 Manufactured No

260

Each

4.0000

1

1

D3558-3

Gasket

**

11/11/20

Location

Loc Qty

Loc Code

FP014

4

71651

1

72170

3

D3558-5 Manufactured No

260

Each

5.0000

1

1

D3558-5

Gasket

**

11/11/20

Location

Loc Qty

Loc Code

FP014

5

67485

5

D3558-7 Manufactured No

260

Each

5.0000

1

1

D3558-7

Gasket

**

11/11/20

Location

Loc Qty

Loc Code

FP014

5

67162

5

NAS1611-007 Purchased No

260

Each

276.0000

2

2

NAS1611-007

O-RING

**

11/11/20

Location

Loc Qty

Loc Code

FP-A

276

103697

276

x2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 1:05:29 PM

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

260

Each

103.0000

4

4

NAS1611-010

O-RING

**

1119438 (x4) Muluh

Location

Loc Qty

Loc Code

FP

89

117460

8

118077

1

118612

80

FP-A

14

110915

14

NAS1611-013

Purchased

No

260

Each

100.0000

4

4

NAS1611-013

O-RING

**

1119307 (x4) Muluh

Location

Loc Qty

Loc Code

FP

55

117291

2

117887

53

FP-A

45

116582

5

118384

40

Purchased

No

280

Each

1,987.000

8

8

AN3C4A

AN3C4A

BOLT

**

11144250

Location

Loc Qty

Loc Code

ST350

1987

117313

2

117688

5

117872

22

118112

16

118451

442

118706

500

118838

1000

118838

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 10

October 13, 2011 1:05:29 PM

Work Order ID: 74935

74935

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 10/13/11

Required Date: 10/21/11

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332
R

Purchased

No

280

Each

0.0000

8

8

***AN960C10I ***

washer

D3512-1

Manufactured

No

280

Each

12.0000

2

2

D3512-1

Wearplate

Location

Loc Qty

Loc Code

ST500

i2

73955

12

73955

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

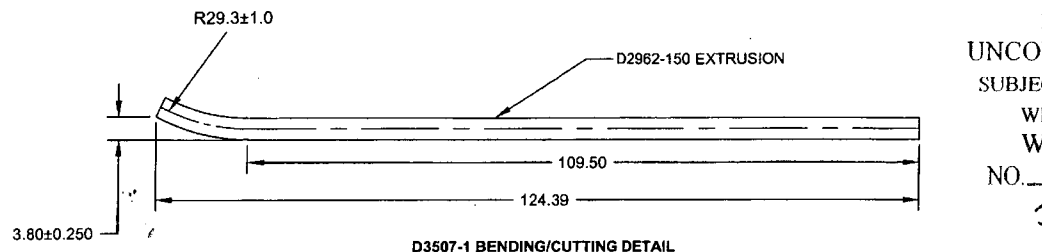
NO. ~~34779~~
74935 M.L.J
11/10/11

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

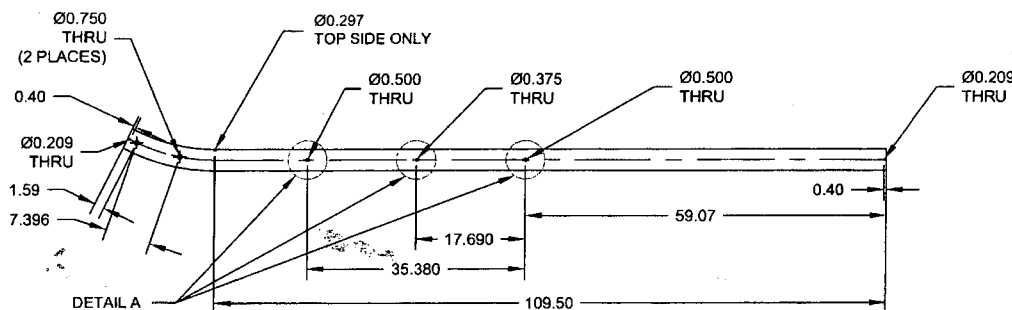
GENERAL NOTES:

- FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

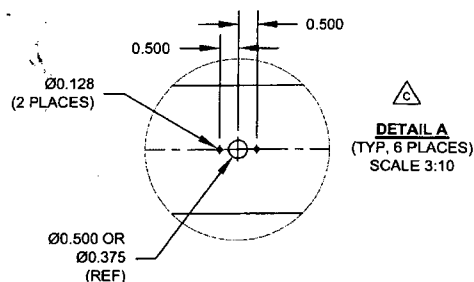
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	HC		
CHECKED	PH		
MFG. APPR.	ED		
APPROVED	ED		
DE APPR.	ED		
DATE	07.09.19		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 REV. C SHEET 1 OF 2 TITLE EC 135 SKIDTUBE NTS <small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

Dart Aerospace Ltd

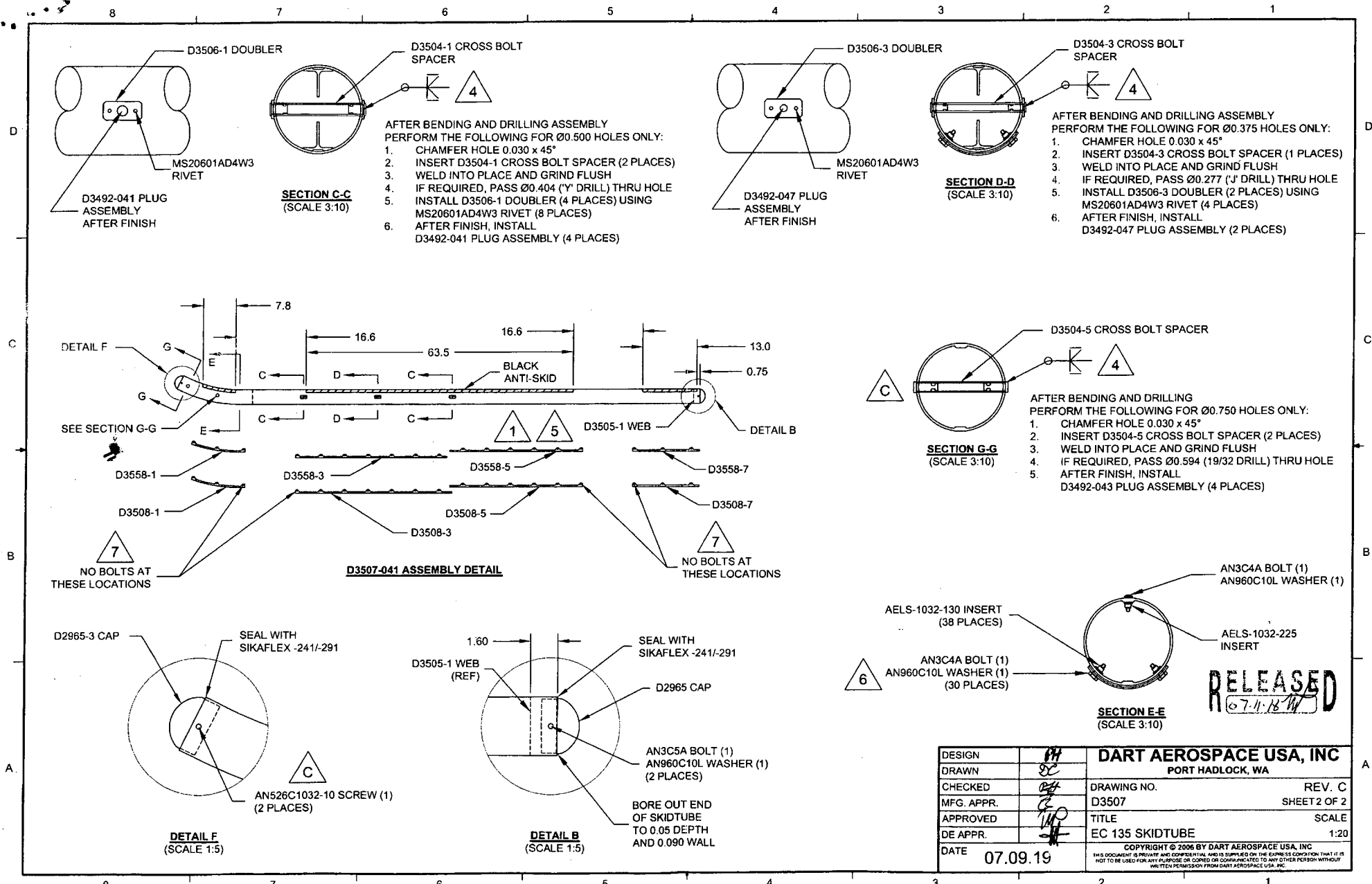
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74935
24429



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

REFERENCE ONLY

IIN-D135-751

Page 11 of 11

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT I
26	8	30	38		*AN960C10L	WASHER I
27	2		2		D3512-1	WEARPLATE I
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: C

Date: 07.09.20

NO. 257

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B6666
Part number: D 135-751-011
Description: 135
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☐ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat. Lewis Date of Test Coupon 11-06-22
Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld